



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2499

Job Sheet 174134



Part No: D2499

Job Qty: 6 ea

Part Name: Mounting Bracket



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/12/18

Job Tracking No:

Due Date: 4/24/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG REV C IPP A 00.06.26 Removed P/O for powder coat EC IPP C Rev C dwg 07-09-25 DD verified by EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	4/24/18	4/24/18	0.00	0.00	Start Up Machining		DAS
100	Bandsaw	6 pcs	4/24/18	4/24/18	0.00	7.36	Bandsaw1		54
110	CNC Vertical Machining	6 pcs	4/24/18	4/24/18	0.42	7.41	HAAS 1		9-89
120	QC	6 pcs	4/24/18	4/24/18	0.00	0.00	QC2		
130	QC	6 pcs	4/24/18	4/24/18	0.00	0.00	QC8		
140	HandFinish	6 pcs	4/24/18	4/24/18	0.00	0.33	HandFinish1		
150	Powdercoat	6 pcs	4/24/18	4/24/18	0.00	0.48	Powdercoat1		
160	QC	6 pcs	4/24/18	4/24/18	0.00	0.00	QC3		
170	Packaging	6 pcs	4/24/18	4/24/18	0.00	0.00	Packaging3		
180	QC21-SA	6 Ea	4/24/18	4/24/18	0.00	0.00	QC21		

Part Op 100 - Cut blanks: 8.500" x 4.000"
Descriptions: 110 - Machine as per folio D2499
150 - *****mask slot as per dwg*****

M 138760 START: 4:55 O.V.T: 320° FINISH: 5:05

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.000X04.000	6061-T6 Bar 1.00 X 4.00	2.4000 ft (.4 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B1.000X04.000	2	44	0

Part Specifications

Specifications could not be found.

Plex 3/12/18 9:59 AM Dart.Gagnon.Michelle

DART
AEROSPACE

1270 KENNEDY QUAY
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S063322



Part: D2499

Job No: 174134

Serial No/Batch: S063322

Revision:

Inspector:

Date: 04/20/18

20

DART AEROSPACE LTD		Work Order: 174134
Description: Mount		Part Number: D2499
Inspection Dwg: D2499 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.585	+/-0.010	0.576	/			
1.252	+/-0.010	1.250	/			
2.085	+/-0.010	2.081	/			
3.585	+/-0.010	3.581	/			
3.960	+/-0.010	3.955	/			
0.375	+/-0.010	0.373	/			
0.875	+/-0.010	0.882	/			
1.500	+/-0.010	1.500	/			
3.525	+/-0.010	3.530	/			
4.150	+/-0.010	4.149	/			
5.200	+/-0.010	5.200	/			
3.460	+/-0.010	3.458	/			
3.335	+/-0.010	3.332	/			
2.541	+/-0.010	2.540	/			
0.25	+/-0.010	0.248	/			
5.700	+/-0.010	5.692	/			
0.115	+/-0.010	0.110	/			
0.770	+/-0.010	0.768	/			
1.000	+/-0.010	0.990	/			
0.25	+/-0.010	0.245	/			
0.38	+/-0.010	0.377	/			
0.250	+/-0.010	0.245	/			
0.500	+/-0.010	0.500	/			
R0.25	+/-0.010	R0.250	/			
R0.50	+/-0.010	R0.500	/			
R0.38	+/-0.010	R0.375	/			
R0.13	+/-0.010	R0.125	/			
R0.25	+/-0.010	R0.250	/			
R0.06	+/-0.010	R0.063	/			
Ø0.257	+0.006/-0.001	0.258				
Ø0.386	+0.006/-0.001	0.387				

Measured by: 54 9-89	Audited by: A.e	Prototype Approval:	N/A
Date: 18/04/16	Date: 18-04-20	Date:	N/A
Rev	Date	Change	Revised by Approved
A	08.04.11	New Issue	KJ/DD [Signature]

DQA: _____ Date: _____

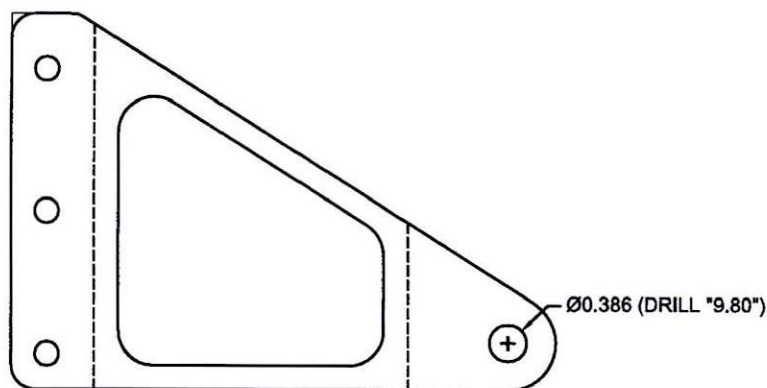
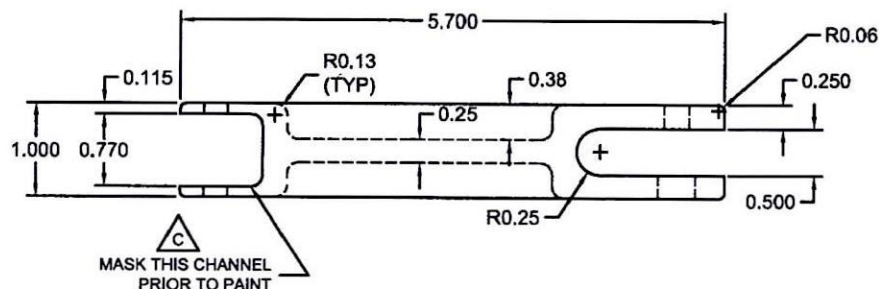
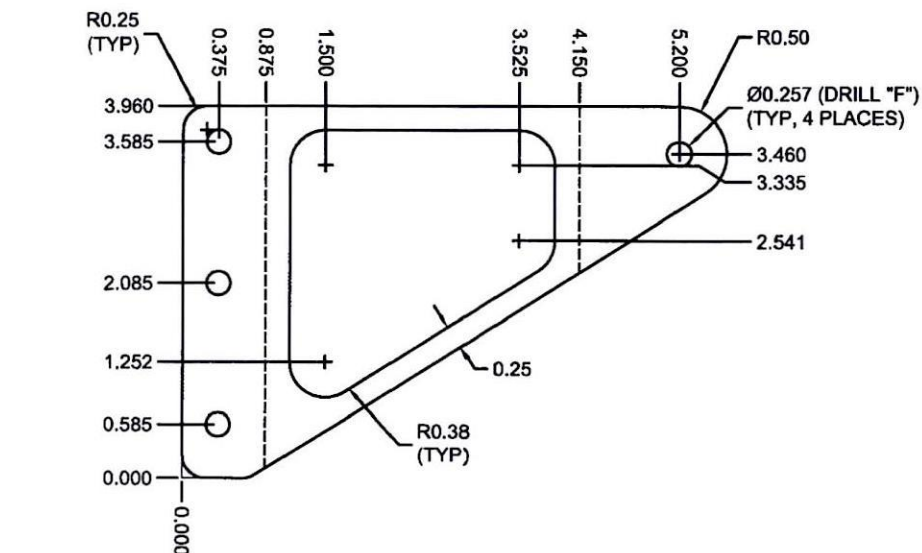


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By																																																									
								Lead hand / Supervisor Approval Verification																																																									
								QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																



RELEASED

07-08-29

D2499 MOUNT

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2499" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.65 lbs

C	- ADDED MASKING DETAIL - DUE TO TIGHT FIT WHEN INSTALLED ON BASKET - ADD MASKING STEP TO ESTIMATE	DC	07.07.25
B	CHANGE HOLE DIA TO .386	KH	95.12.06
A	NEW ISSUE	BW	95.11.09
REV.	DESCRIPTION	BY	DATE
DESIGN	B WILLIAMS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>DC</i>		
CHECKED	<i>DC</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>DC</i>	D2499	SHEET 1 OF 1
APPROVED	<i>DC</i>	TITLE	SCALE
DE APPR.	<i>DC</i>	MOUNT	1:2
DATE	07.07.25	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	